



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA3-3
Job Sheet 173287



Part No: SWA3-3

Job Qty: 1 ea

Part Name: Electric Swivel 3,000 lb Safe Work Load (1,360 Kg)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/27/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA3-3 Rev 3 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/15/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		3/16/18	0.00	2.00	Small Fab-6		
120	QC	1 pcs		3/16/18	0.00	0.00	QC5		
130	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		3/16/18	0.00	0.00	QC21		

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA3 swivel manual*** Engrave Descriptions: T/N And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

130 - Bag and tag

DAS
21
2018

MAR 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-832-1/4	Set Screw	1 Ea (1 ea)	90-Start up Operation	S 027241
330	Rotary Connector	1 (1 ea)	110-Small Fab	S 027242
92210A303	Flat Socket Cap Screw	4 pcs (4 ea)	110-Small Fab	S 027242
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	S 027242
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	S 027242
EL314-SJTOW	3 Wire	6 ft (6 ea)	110-Small Fab	S 027242
SWA3-100	Upper End - Swa3 Swivel	1 Ea (1 ea)	110-Small Fab	S 027242
SWA3-200	Lower End	1 Ea (1 ea)	110-Small Fab	S 027242
SWA3-300	Wire Clamp	2 Ea (2 ea)	110-Small Fab	S 027242
SWA3-400	Button Head Screw	2 Ea (2 ea)	110-Small Fab	S 027242
SWA3-500B	Contact Spacer	1 Ea (1 ea)	110-Small Fab	S 027242
SWA3-600	O-Ring	1 Ea (1 ea)	110-Small Fab	S 027242
SWA3-700	Ball Bearing	32 Ea (32 ea)	110-Small Fab	S 027242
SWA6A-1900	Female Spade Terminal - 1/4"	6 Ea (6 ea)	110-Small Fab	S 027242

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-832-1/4	1	96	0
110-Small Fab	330	1	0	0
	92210A303	4	100	0
	EL-PLUG-F	1	38	0
	EL-PLUG-M	1	35	0
	EL314-SJTOW	6	247	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____				MRB (QS1042) Approval			
Description Work Order Deviation				Disposition				Completed By			
• USED SHRINK TUBE AND SILICONE ON ROTARY CONTACT TERMINALS TO INSULATE • USED INSTALLED "DART" STICKER NO D 2728-1 INSTEAD OF LASER ENGRAVING								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐										
Misidentified ☐	Past Due ☐	OTHER : _____									

SWA3-100	1	0	0
SWA3-200	1	0	0
SWA3-300	2	0	0
SWA3-400	2	0	0
SWA3-500B	1	0	0
SWA3-600	1	0	0
SWA3-700	32	300	0
SWA6A-1900	6	88	0

Part Specifications

Specifications could not be found.

Plex 2/27/18 1:48 PM Dart.lajeunesse.marie



Container No: S046976



Part: SWA3-3

Job No: 173287

Serial No/Batch: S046976

Revision: 3

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/01/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

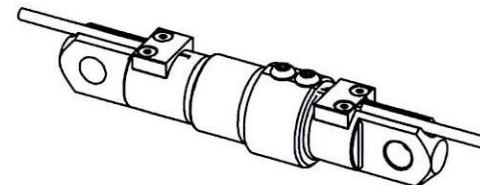
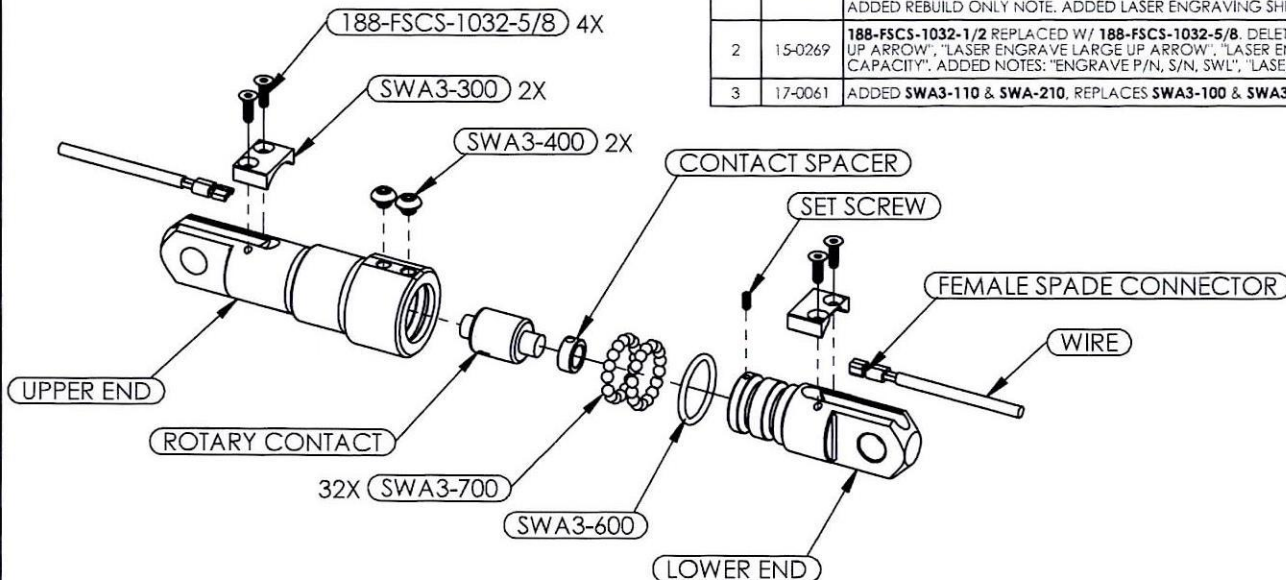
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Misidentified ☐	Past Due ☐																								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		REPLACED ID DECAL 600.1318 WITH LASER ETCHING	11/16/2012	JAG	
B		REMOVED 2 WIRE HARNESS	8/8/2013	JAG	RW
1	15-0079	UPDATED TO NEW DRAFTING STANDARDS. ADDED SWA6A-2000, 188-FPSS-832-3/8, EL314-SJTOW CH'D QTY'S: -2 ASSY WAS 6 IS 1, -3 ASSY WAS 6 IS 1, ADDED 6 FT. TO B/O INFO. EL404-ARTIC CH'D QTY'S: -4 ASSY WAS 6 IS 1, ADDED 6 FT. TO B/O INFO. SWA6A-1900 CH'D QTY'S: -4 ASSY WAS 8 IS 4, ADDED REBUILD ONLY NOTE, ADDED LASER ENGRAVING SHEET.	4/16/2015	DPD	JAG
2	15-0269	188-FSCS-1032-1/2 REPLACED W/ 188-FSCS-1032-5/8. DELETED NOTES: 2X "LASER ENGRAVE SMALL UP ARROW", "LASER ENGRAVE LARGE UP ARROW", "LASER ENGRAVE DART LOGO P/N S/N CAPACITY". ADDED NOTES: "ENGRAVE P/N, S/N, SWL", "LASER ENGRAVE DART LOGO".	9/23/2015	DPD	JAG
3	17-0061	ADDED SWA3-110 & SWA-210, REPLACES SWA3-100 & SWA3-200 IN -4 ASSY.	3/23/2017	DPD	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 172236 MJS
173287 18-02-14

-2 QTY.	-3 QTY.	-4 QTY.	B/O	Part #	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
1	1	-		SWA3-100	UPPER END			1
-	-	1		SWA3-110	UPPER END			1
1	1	-		SWA3-200	LOWER END			1
-	-	1		SWA3-210	LOWER END			1
2	2	2		SWA3-300	WIRE CLAMP			1
2	2	2		SWA3-400	BUTTON HEAD SCREW			1
1	-	-		SWA3-500	CONTACT SPACER			1
-	1	1		SWA3-500B	CONTACT SPACER			1
1	1	1		SWA3-600	O-RING			1
32	32	32	B/O	SWA3-700	BALL BEARING	S.S.	Ø1/4 MCMASTER-CARR #9529K15	1
1	-	-	B/O	SWA6A-900A	ROTARY CONTACT		MERCOTAC #230	1
-	1	-	B/O	SWA6A-900B	ROTARY CONTACT		MERCOTAC #330	1
-	-	1	B/O	SWA6A-900C	ROTARY CONTACT		MERCOTAC #430	1
4	4	4	B/O	188-FSCS-1032-5/8	FLAT SOCKET CAP SCREW	S.S.	10-32 x 5/8 (MCMASTER-CARR #92210A303)	1
1	1	-	B/O	EL314-SJTOW	3 WIRE		6 FT. (TEXCAN #EL 314-SJ TOW 3/14)	1
-	-	1	B/O	EL414-ARTIC	4 WIRE		6 FT. (TRUCK & AUTO SUPPLY #EL 414-ARTIC 4/14)	1
-	1	1	B/O	188-FPSS-832-1/4	SET SCREW	18-8 S.S.	8-32 X 1/4 MCMASTER-CARR #92311A190	1
1	-	-	B/O	188-FPSS-832-3/8	SET SCREW	S.S.	8/32 X 3/8 (MCMASTER-CARR #92311A192)	1
4	6	4	B/O	SWA6A-1900	1/4" FEMALE SPADE CONNECTOR		(MCMASTER-CARR #69525K16)	1
-	-	4	B/O	SWA6A-2000	1/8" FEMALE SPADE CONNECTOR		(MCMASTER-CARR #69525K14)	1
1	1	1	B/O	600.1319	UP DECAL			N/S
1	1	1	B/O	EL-PLUG-F	FEMALE PLUG	PE High Density	(MCMASTER-CARR #7216K6)	1
1	1	1	B/O	EL-PLUG-M	MALE PLUG	PE High Density	(MCMASTER-CARR #7216K5)	1
-2 QTY.	-3 QTY.	-4 QTY.						

NOTES:

1. ALL ASSEMBLY TO BE DONE IN ACCORDANCE WITH SWA3 SWIVEL MANUAL.

2. FOR CUSTOMER REBUILD ONLY.

DART
AEROSPACE
SWA3 SWIVEL

TITLE

DWG NO.

SWA3

REV
3

MAT'L

HEAT

TREAT

FINISH

SPEC

DRAWN BY:

CANAM

CHECKED:

SM 03/23/2017

OPPS APPR:

AA 03/28/2017

QA APPR:

JL 04/05/2017

APPROVED:

JAG 04/11/2017

SCALE

1:4

DATE

SHEET 1 OF 2

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
.X ± .1 SURFACES = 125/

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

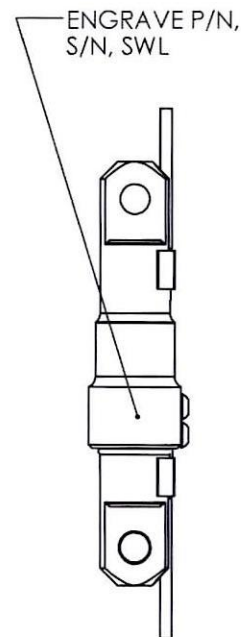
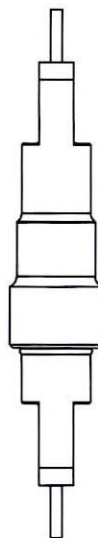
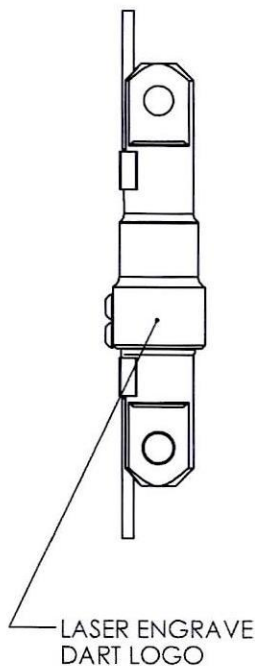
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
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Root Cause				FAULT CATEGORY							
Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐							
OTHER :											

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DART AEROSPACE	
TITLE SWA3 SWIVEL	
DWG NO. SWA3	REV 3
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: SM 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 03/28/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 04/05/2017	USED ON MODEL
APPROVED: JAG 04/11/2017	
SCALE 1:4	DATE
SHEET 2 OF 2	

DQA: _____ Date: _____



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OTHER : ☐																									



Electric Swivel
SWA3

Work Order 173287

Customer _____

Number of Wires 3

Date 2018/03/09

Serial Number S046976

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	3,000	Check for Conductivity against all wires.	- Pass
1	3,000	Check all wires for grounding against swivel body.	- Pass
1	1,500	Check for Conductivity against all wires.	- Pass
1	1,500	Check all wires for grounding against swivel body.	- Pass
1	750	Check for Conductivity against all wires.	- Pass
1	750	Check all wires for grounding against swivel body.	- Pass
1	0	Check for Conductivity against all wires.	- Pass
1	0	Check all wires for grounding against swivel body.	- Pass

Test Conducted By: ALAIN PATRY
Technician

Signature: 
Director of Quality Assurance

Submit